

Thursday, 29/11/2007 2:55:36 PM
Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: DISASSEMBLE/SCRAP	
Job Number	: 36069		Part Number	: D412705013	
Estimate Number	: 10804		Drawing Number	: ECN 1052	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 29/11/2007		Drawing Revision	: N/A	
Prsht Rev.	: NG		Material	: N/A	
First Issue	: N/A		Due Date	: 06/12/2007	
Previous Run	: 00015		Qty:	2	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
REMOVE FROM STOCK: 2 X D412-705-013 B23260 <i>W 07/12/04</i> <i>Rept D 3245-043</i>		
REMOVE D3245-041 & D3245-042 & SCRAP PER ECN1052 <i>PP 07/12/04</i>		
2.0	D412705013	Intake Plenum Access Pnl
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Intake Plenum Access Pnl		
<i>03 07/12/04</i>		

3.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

03 07/12/05

Job Completion



W 07/12/05

Description: Intake Plenum Access Panel Kit	Part Number:	D412-705-013
Dwg: D3245 Rev. A	Qty:	12 Kit(s)
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																								
7	GA	Assemble (2) D3245-043. Transfer holes from D3245-3 to D3245-7 gasket after bonding gasket as per Dwg D3245 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D3245-3</td><td>Door</td><td>B23260</td></tr><tr><td>2</td><td>D3245-7</td><td>Gasket</td><td>B23260</td></tr><tr><td>16</td><td>127H-35</td><td>Half Grommet</td><td>M15417</td></tr><tr><td>16</td><td>2351-20-009-C3Y</td><td>Stud</td><td>M17816</td></tr><tr><td>A/R</td><td>1300/1300L</td><td>3M scotch-grip adhesive</td><td>M18025</td></tr></tbody></table> Identify as D3245-043	Qty	Part Number	Description	Batch	2	D3245-3	Door	B23260	2	D3245-7	Gasket	B23260	16	127H-35	Half Grommet	M15417	16	2351-20-009-C3Y	Stud	M17816	A/R	1300/1300L	3M scotch-grip adhesive	M18025			
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A/R	1300/1300L	3M scotch-grip adhesive	M18025																										
8	QC5	Inspect work to Step 7.		205-08-11	12																								
9	GA	Install D3245-043 Door Assembly into each of D3245-041/-042 Panel Assemblies.	SP	05/08/11	12																								
10	KP	Pick: Packing Kit (Note: D3245-043 is installed into each of D3245-041/-042 assemblies. <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3245-041</td><td>Panel Assembly</td><td>B23260</td></tr><tr><td>1</td><td>D3245-042</td><td>Panel Assembly</td><td>B23260</td></tr><tr><td>2</td><td>D3245-043</td><td>Door Assembly</td><td>B23260</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3245-041	Panel Assembly	B23260	1	D3245-042	Panel Assembly	B23260	2	D3245-043	Door Assembly	B23260											
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1	D3245-041	Panel Assembly	B23260																										
1	D3245-042	Panel Assembly	B23260																										
2	D3245-043	Door Assembly	B23260																										
11	QC4	Inspect Kit 100% for Completeness on the W/O		205-08-12	12																								
12	PK	Identify and pack for shipping as per PPP D412-705-013 REV. A	CL	05/08/12	12																								
13	AC	Cost / part 255.26	S42	05/08/12	12																								
14	DC	Close W/O 255.26 Inspect Level 21	(15)	05/08/12	12																								

Rev	Date	Change	Revised By	Approved
A	04.03.25	New issue	KJ/RF	
B	04.07.07	Changed step 1,3,5 & 7	KJ/JLM	<i>JLM</i>

RELEASED

04/07-08

Description: Intake Plenum Access Panel Kit	Part Number:	D412-705-013
Dwg: D3245 Rev. A	Qty:	12 Kit(s)
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty	
1	DC	Issue Travelers for: D412-705-013 Intake Plenum Access Pnl D3245 Gasket (Roll) D3245-1 Panel D3245-2 Panel D3245-3 Door D3245-5 Angle Plate D3245-7 Gasket Note: D412-705-013 consists of (1) D3245-041; (1) D3245-042; (2) D3245-043. D3245-041 consists of (1) D3245-1; (1) D3245-5. D3245-042 consists of (1) D3245-2; (1) D3245-5. D3245-043 consists of (1) D3245-3.	Batch 23260 23260 23260 23260 23260 23260 23260 23260	KJ	05.05.16	12
2	DC	Photocopy bluefile and create labels per PPP D412-705-013 CHG001	WK 21	DT	05.06.09	
3	GA	Assemble D3245-041. Transfer holes from D3245-1 to D3245 gasket after bonding gasket using 3M Scotch-grip as per Dwg D3245 Pick: Qty Part Number Description Batch 1 D3245-1 Panel B23260 1 D3245-5 Angle Plate B23260 8 2350-18-C3Y Dzus Rigid Receptacle M17648 18 MS20427M3-3 Rivet M17654 9 MS20615M3-3 Rivet M14940 1 MS21060-L3K Nut Plate M17654 A/R 1300/1300L 3M scotch-grip adhesive M18025 A/R D3245 Gasket B23260 Identify as D3245-041	SB 05/08/05		12	
4	QC5	Inspect work to Step 3		2	05.06.11	
5	GA	Assemble D3245-042. Transfer holes from D3245-2 to D3245 gasket after bonding gasket using 3M Scotch-grip as per Dwg D3245 Pick: Qty Part Number Description Batch 1 D3245-2 Panel B23260 1 D3245-5 Angle Plate B23260 8 2350-18-C3Y Dzus Rigid Receptacle M17648 18 MS20427M3-3 Rivet M17654 9 MS20615M3-3 Rivet M14940 1 MS21060-L3K Nut Plate M17654 A/R 1300/1300L 3M scotch-grip adhesive M18025 A/R D3245 Gasket B23260 Identify as D3245-042	SB	05/08/05	12	
6	QC5	Inspect work to Step 5		2	05.06.09	